

Date: Thursday, 08/05/2008 12:00:23 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY
 Job Number : 39128
 Estimate Number : 10699
 P.O. Number :
 This Issue : 08/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3391025
 First Issue : / / Type : CROSSTUBES Drawing Number : D3391 REV G
 Previous Run : 36843 Drawing Revision : G
 Material :
 Due Date : 30/05/2008 Qty: 1 Um: Each

Written By :
 Checked & Approved By : JUD 08.5.08
 Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC
 Est Rev:C 06-03-28 Update Manuf. Instructions JLM

est rev D 07.03.20 revF dwg EC
 est rev E 07.11.07 rev G dwg ecn 1053p EC verified by:
 DD
 Est Rev:F 07-11-13 ECN 1056 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 332309

Identify as D3391-3

am 08.05.27 ①

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: G

am 08.05.27 ①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

am 08.05.28 ①

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: G

2-Deburr

5.1 08/07/031

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/07/31

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

27 08/08/01 (1)

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 8-8-5

8.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 8-8-5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/05 (x6)

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'sink as per dwg D3391

6-Open up all wearshoe , wearplate and float bag holes as per Dwg D3391.

7-Deburr

8-8-6
8-8-7

Tools: rill

W/O:		WORK ORDER CHANGES					
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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/8/08

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

08.08.08

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11-8-12

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch:

36817

11-8-12

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398

Batch: 1107621

exp. date: 9-8-1

cure time 12hrs as per QSI0015

11-8-12

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11-8-14

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320°F
11:30

11-8-14 08/08/14

(1X)

W/O:		WORK ORDER CHANGES					
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Job Number: 39128

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-14

(X)

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number Description Batch

1

D2646

Aft Cap

B36184 *

HL

20.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

B38941

HL

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

B33869

HL

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B33868

HL

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B33870

HL

24.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

B39275

HL

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

batch: M105819

HL

08-08-14

RD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 39128

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent per
QSI 017

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
INSERT
or equivalent
Per QSI 017 M 100489 92

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Pick:
Qty Part Number Description Batch
2 AN3C4A Bolt M 108599 92

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt M 108744 92 *

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Inventory
Pick:
Qty Part Number Description Batch
2 AN960C10L Washer M 108678 92

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Install inserts as per Dwg D3391
2-Install Aft Cap as per Dwg D3391
A/R Sikaflex-241/-291 M 108801
Sikaflex expiry date: 08/10

92 08.08.15 (2)

W/O:		WORK ORDER CHANGES					
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Job Number: 39128

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



08-08-18



Comment: INSPECT WORK TO CURRENT STEP

32.0

PACKAGING 1

PACKAGING RESOURCE #1



(12)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ADD 39103

8/8/18

SC

33.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-19

DART AEROSPACE LTD		Work Order: 39128
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.501	✓			
88.93	+/-0.030	88.937	✓			
44.995	+/-0.030	45.250	✓			
3.200	+/-0.010	3.203	✓			
1.526	+0.000/-0.030	1.510	✓			
0.200	+/-0.010	.201	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.302	✓			
0.200	+/-0.010	.205	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.486	✓			

Measured by: A.M./J.L.	Audited by: S.P.	Prototype Approval:	N/A
Date: 08.05.20	Date: 08/05/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update.	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	

